

53.88

Dart Aerospace Ltd.

Date: Monday, 4/23/2007 3:41:40 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 32018A	
Estimate Number : 10338	
P.O. Number : NA	Part Number : D2657
This Issue : 4/23/2007 S.O. No. : N/A	Drawing Number : D2657 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : NA	Drawing Revision : A
Previous Run : 29780A	Material : N/A
	Due Date : 5/18/2007
Written By : <u> </u>	Qty: <u>30</u> Um: Each
Checked & Approved By : <u> </u>	
Comment : Est Rev: A New Issue 05-11-07 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B0750X02500	ASTM A21 Steel .75"x2.5"
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Comment: Qty.: 0.1925 f(s)/Unit Total : 57.9320 f(s)
 Material: ASTM A36 steel bar 2.50" x 0.75" thick
 (M1010-B0.750 x 02.500)
 Batch M10Y288

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW
 Cut blanks: 2.200" long

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine per folio FA040 and Dwg D2657

2-Deburr

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/05/28
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *STY*

6/20/08

30

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SD 07/05/08

Job Completion



6/07/08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

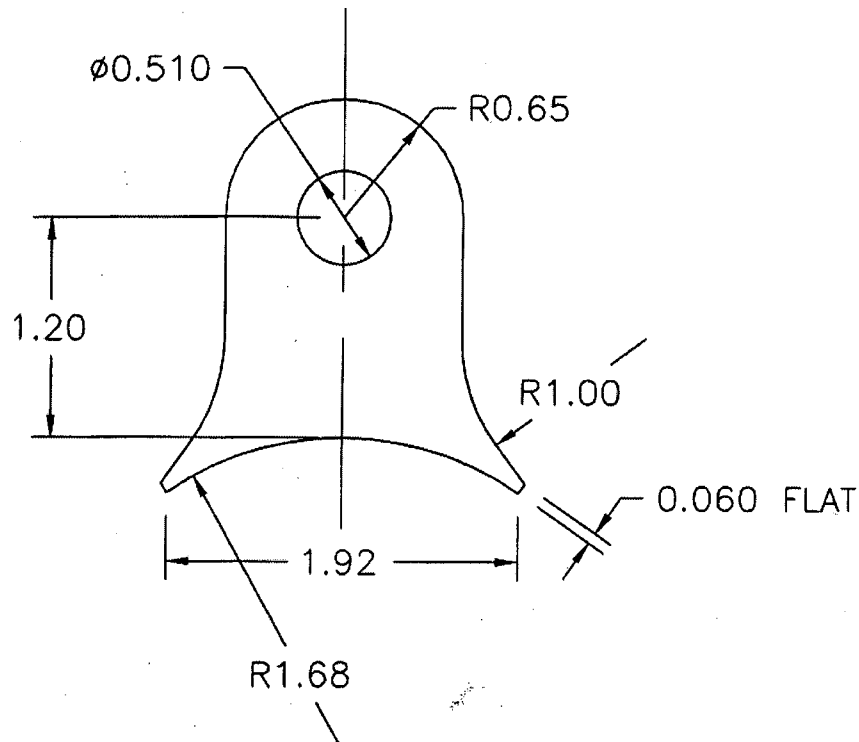
NOTE: Date & initial all entries



DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2657	REV. A SHEET 1 OF 1
DATE 97.11.03		TITLE LUG	SCALE 1:1
A	97.11.03	NEW ISSUE	

RELEASED
97/11/07 DS



0.063 *[Signature]* 00.04.05

BREAK ALL SHARP CORNERS ~~0.010 TO 0.020~~

MATERIAL: ASTM A36 STEEL 0.375 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

PART IS SYMMETRIC ABOUT CENTER-LINE

SHOP COPY
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
32018A